

5/13

SPLIT



2


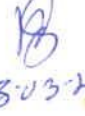


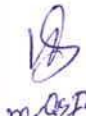



DART AEROSPACE LTD	Work Order:	22515 B
Description: Bracket Assembly	Part Number:	D2804-041
Dwg: D2804 Rev. B	Qty:	20 15
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	HA	05.02.23	20																				
2	GA	Press D2805-1 into arm as per Dwg D2804 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2804-1</td><td>Bracket</td><td>B22525</td></tr><tr><td>1</td><td>D2805-1</td><td>Stop</td><td>B22522</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2804-1	Bracket	B22525	1	D2805-1	Stop	B22522	1	D2809	Bushing	B22529	SB	05/03/23	20				
Qty	Part Number	Description	Batch																						
1	D2804-1	Bracket	B22525																						
1	D2805-1	Stop	B22522																						
1	D2809	Bushing	B22529																						
3	QC5	Inspect work to Step 2	HA	05.03.23	20																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05/03/24	20																				
5	QC3	Inspect Powder Coat	ML	05.03.24	20																				
6	GA	Press D2809 into arm as per Dwg D2804	SB	05/03/28	15																				
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>M17046</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M15929</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M16941</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M16863</td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	M17046	2	MS21042L3	Nut (or -3)	M15929	4	NAS1515H3	Washer	M16941	A/R	LPS-3	Corrosion Spray	M16863	SB	05/03/28	15
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	M17046																						
2	MS21042L3	Nut (or -3)	M15929																						
4	NAS1515H3	Washer	M16941																						
A/R	LPS-3	Corrosion Spray	M16863																						
8	GA	Assemble as per Dwg D2804.	SB	05/03/28	15																				
9	QC5	Inspect work to Step 8	Z	05.03.28	15																				
10	ST	Identify and Stock	SB	05/06/09	15																				
11	AC	Cost / part: 60.36	AP	05/06/13	15																				
12	DC	Close W/O 37.79 Inspect Level 21	HA	05.06.16	15																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	

RELEASED
05/05/23

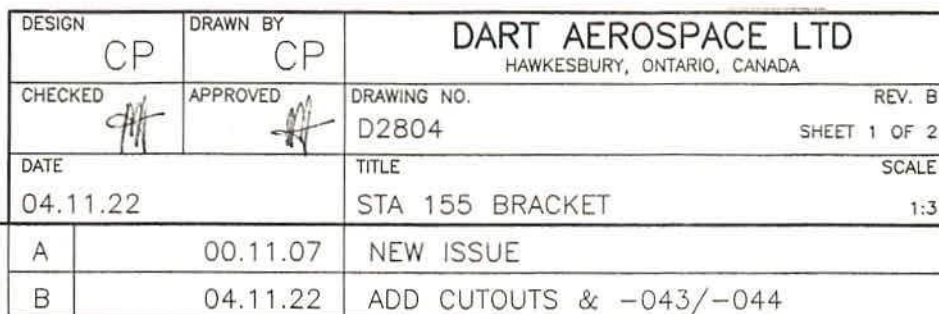
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-03-28	7	ms21042L3 nuts replaced by ms21043-3 nuts	SP SP	05.03.28	2	 05-03-28	 05-03-28

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/28	7	w/o Bain had wrong nuts changed MS21042L3 for MS21043-3	 05-03-28	Scrap 34 MS21042L3	SP 05/03/28	 05-03-28	 05-03-28	 05-03-28
05-03-31	7	D 2808 & D 2809 were stored in boxes under wrong p# therefore wrong bushing was installed in brackets	 05-03-31	remove bushings and press fit proper bushing	SP 05/03/31	 05-03-31	 05-03-31	 05-03-31
05-03-31	4	Too much paint See NCR 840						

Part No: D2804-041 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/06/16

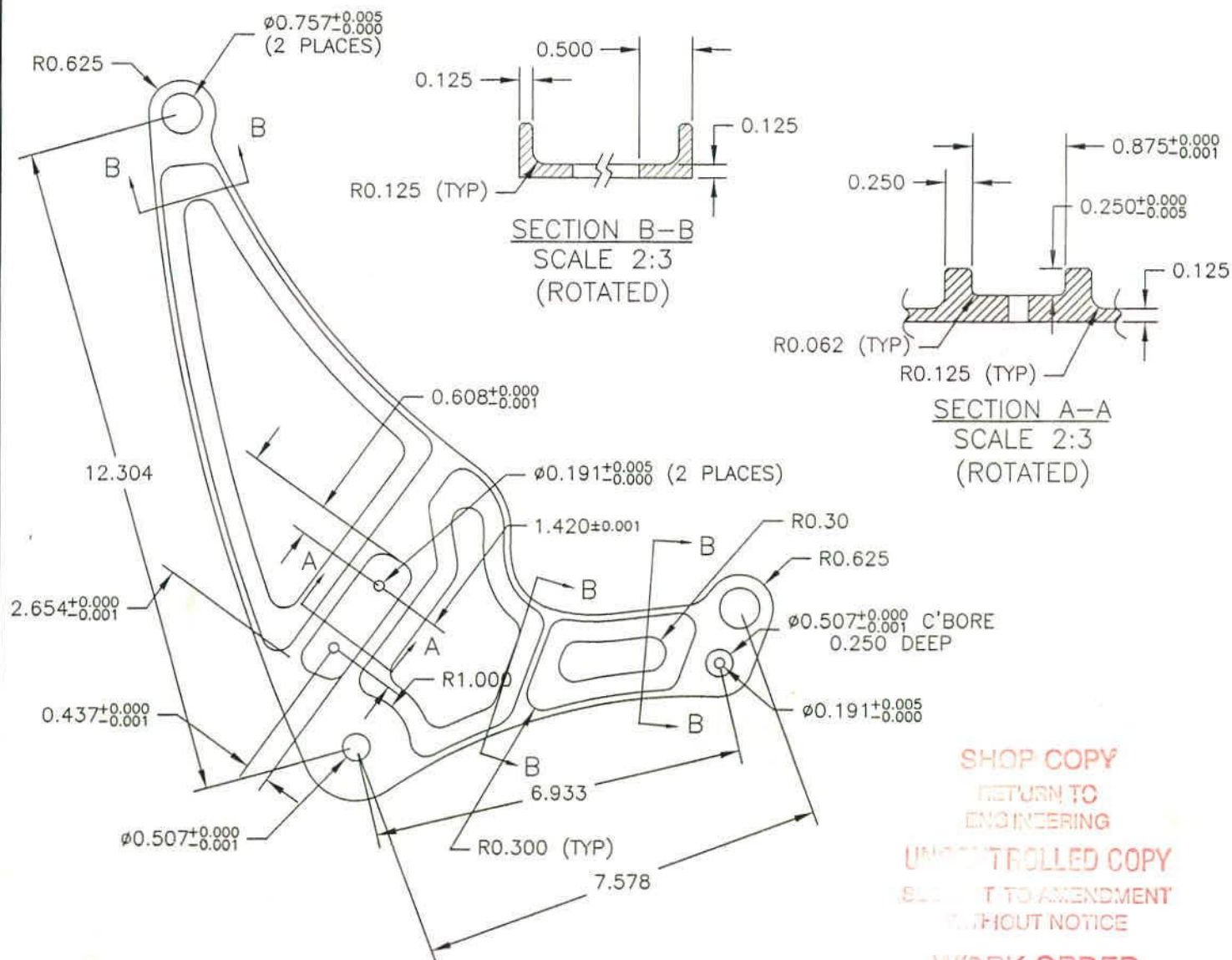
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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05.03.11



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WORK ORDER

NO. 22515

D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

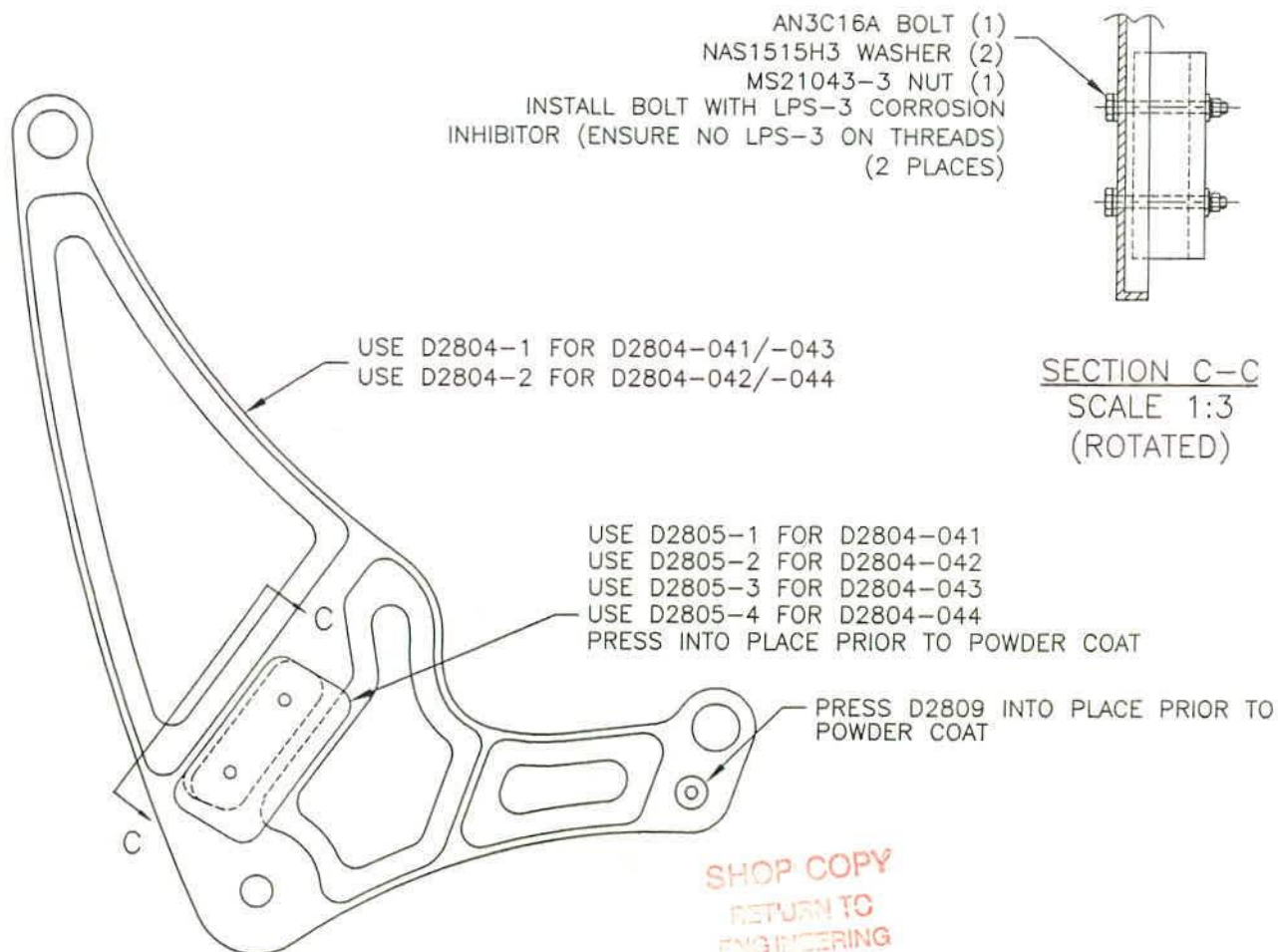
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



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NO. 22515

RELEASED

05-03 11

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No : 0022515
Project Name : D2804-041
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D2804-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 02-22-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00